

# SUPERGLAZE® 5356

Aluminum • AWS ER5356

## KEY FEATURES

- General purpose filler alloy for welding 5XXX series alloys
- The most widely used aluminum-magnesium welding alloy
- High strength filler metal
- AluMAX™ compatible: 0.072 in. (1.8 mm) Gem-Pak® compatible with AluMAX™ welding process for higher deposition and faster travel speeds
- Q2 Lot® - Certificate showing actual wire composition

## WELDING POSITIONS

All, except vertical down

## SHIELDING GAS

100% Argon  
Argon / Helium Mixtures  
Flow Rate: 30 - 50 CFH

## NOTE

- Typical Joint Designs and Operating Procedures on pg. J-14 - J-16
- Gem-Pak®: Use Accu-Pak® Payoff Kit (K2175-2) for payoff

## CONFORMANCES

AWS A5.10:	ER5356
ABS/AWS:	ER5356
ASME SFA A5.10:	ER5356
Lloyd's Register:	WB/I-1 S
DNV:	5356 I-1
BV Grade:	WB
CWB/CSA W48:	ER5356
KR:	WB G I-1
TUV and DB:	Al 5356 (AlMg5Cr(A))
ISO 18273:	AlMg5Cr(A)
CCS:	WB I-1
RINA:	WB I-1

## TYPICAL APPLICATIONS

- Shipbuilding
- General fabrication
- Trailer Manufacturing

## DIAMETERS / PACKAGING

Diameter in (mm)	1 lb (0.4 kg) Plastic Spool 20 lb (9.1 kg) Master Carton	16 lb (7.3 kg) Plastic Spool	20 lb (9.1 kg) Plastic Spool	300 lb (136 kg) Gem-Pak® Box
0.035 (0.9)	ED030312	ED028385		ED034722
3/64 (1.2)	ED030314		ED030282	ED034550
1/16 (1.6)			ED030283	ED034551
0.072 (1.8)				ED038327

## WIRE COMPOSITION<sup>(1)</sup> – As Required per SFA/AWS A5.10

	%Al	%Si	%Fe	%Cu	%Mn
Requirements - AWS ER5356	Remainder	0.25 max	0.40 max	0.10 max	0.05 - 0.20
Typical Results <sup>(2)</sup>	Remainder	0.05	0.09	0.03	0.12
	%Mg	%Cr	%Zn	%Ti	%Be
Requirements - AWS ER5356	4.50 - 5.50	0.05 - 0.20	0.10 max	0.06 - 0.20	0.0003 max
Typical Results <sup>(2)</sup>	4.90	0.08	< 0.01	0.15	0.0002

<sup>(1)</sup>Typical all weld metal. <sup>(2)</sup>See test results disclaimer

*Safety Data Sheets (SDS) and Certificates of Conformance are available on our website at [www.lincolnelectric.com](http://www.lincolnelectric.com)*

FUMES AND GASES can be hazardous to your health.

- Fumes from the normal use of this product contain significant quantities of potentially hazardous compounds. See consumable product label/insert.
- Keep your head out of the fumes.
- Use enough ventilation and local exhaust to keep fumes and gases from your breathing zone and the general area.
- An approved respirator should be used unless exposure assessments are below applicable exposure limits.

#### **TEST RESULTS**

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

#### **CUSTOMER ASSISTANCE POLICY**

The business of Lincoln Electric is manufacturing and selling high quality welding equipment, automated welding systems, consumables, cutting equipment and EV charging systems. Our challenge is to meet the needs of our customers, who are experts in their fields, and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or technical information about their use of our products. Our employees respond to inquiries to the best of their ability based on information and specifications provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment, or to provide engineering advice in relation to a specific situation or application. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or communications. Moreover, the provision of such information or technical information does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or technical information, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose or any other equivalent or similar warranty is specifically disclaimed.

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